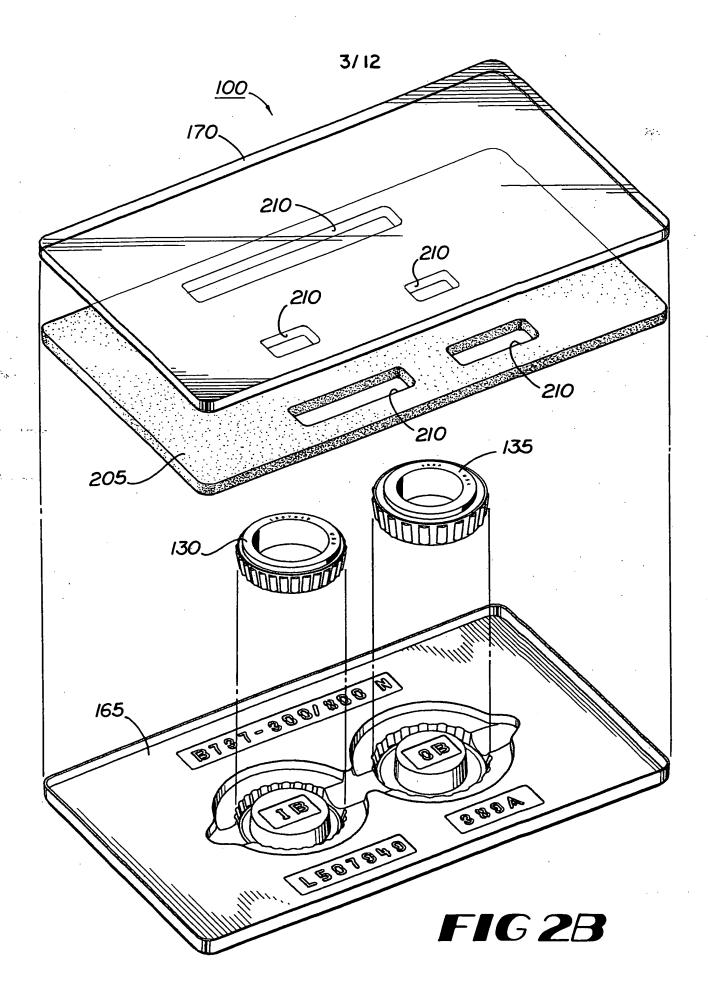


FIG 2A



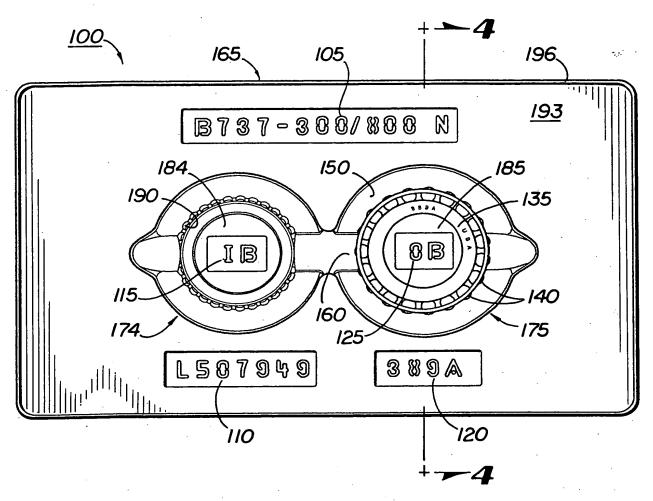
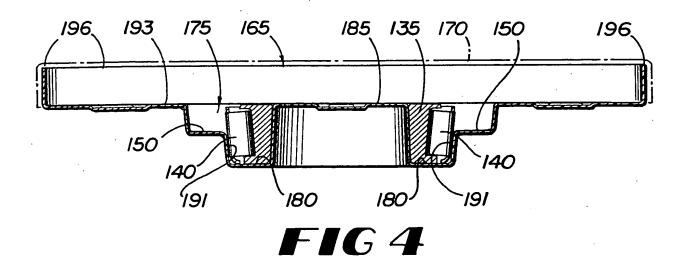


FIG 3





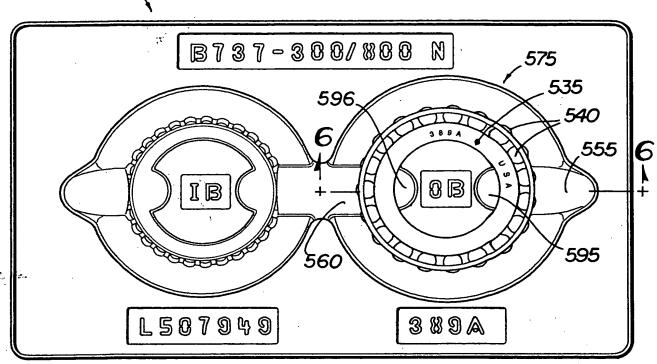
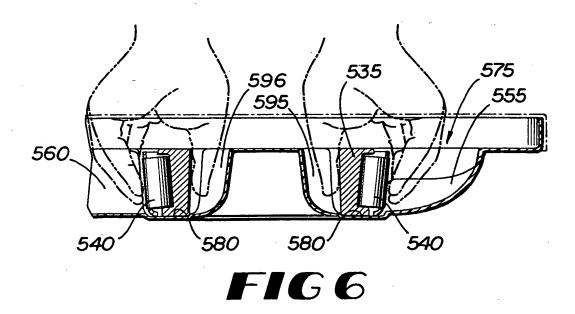


FIG 5



TE	EARING DOWN OF WHEEL ASSEMBLIES	<u>700</u>
WORN WHEE ASSEMBLIES BRO TO SHOP BEARINGS AR REMOVED AND PLACED ON RACKS THEN SE TO CLEANING	WHEEL HALVES ARE PLACED ON CONVEYERS TO BE CLEANED,	00
e de la companya de l	INSTALLED	
710 CLEANING	WHEEL OO WASHER	
SHOP		
BEARINGS ARE CLEANED AND DRIED IN	INSPECTION O	
BEARING WASHER	00	
	SQUAWKING AND PIECE PART INSTALLATION	
BEARINGS SENT TO STATION 720 ON FIG. 7B	WHEELS SENT TO BUILD UP FOR FINAL ASSEMBLY ON ROBOT	

## CONSTRUCTING WHEEL ASSEMBLIES

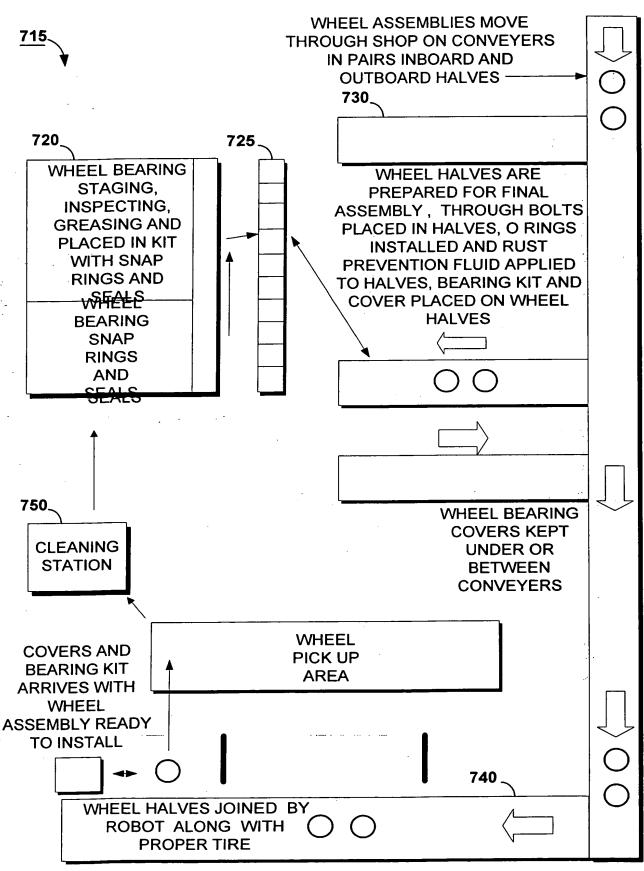
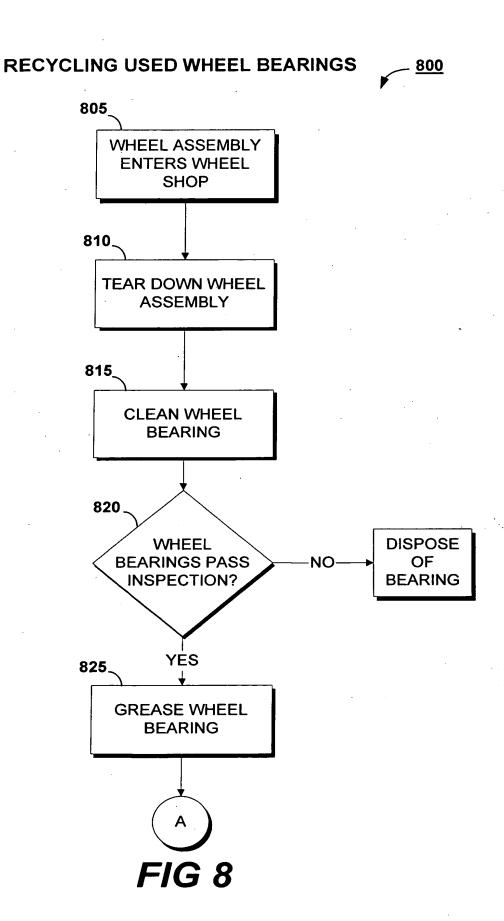


FIG 7B

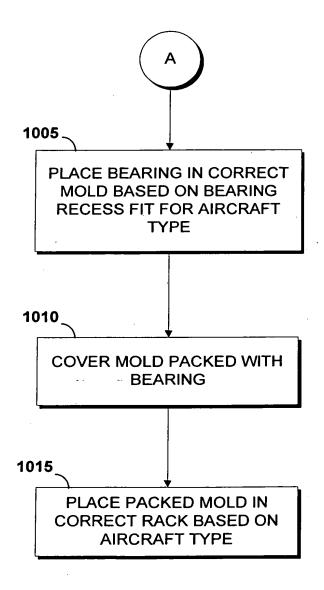


## **INCORPORATING NEW WHEEL BEARINGS** 900 905 **OPEN NEW WHEEL BEARING PACKAGE** 910. **DISPOSE** WHEEL BEARING OF **PASS** NO. **BEARING INSPECTION?** YES 915 **GREASE WHEEL BEARING**

FIG 9

## PACKING WHEEL BEARINGS INTO MOLDS

1000



**FIG 10** 

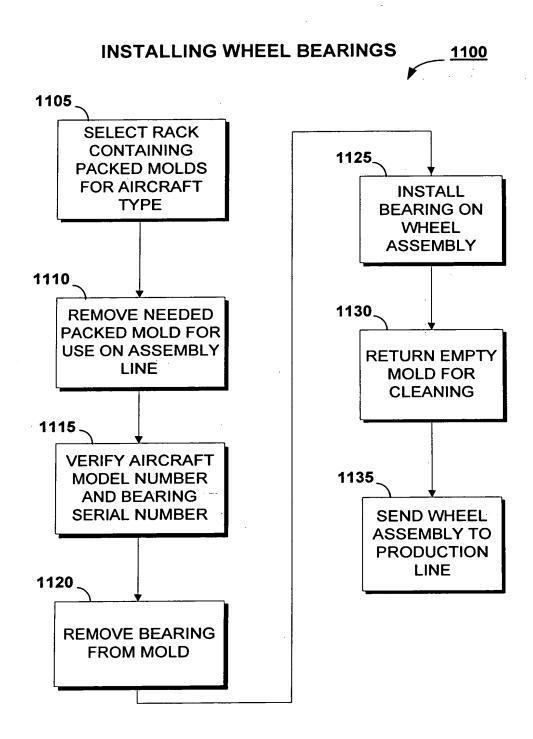


FIG 11

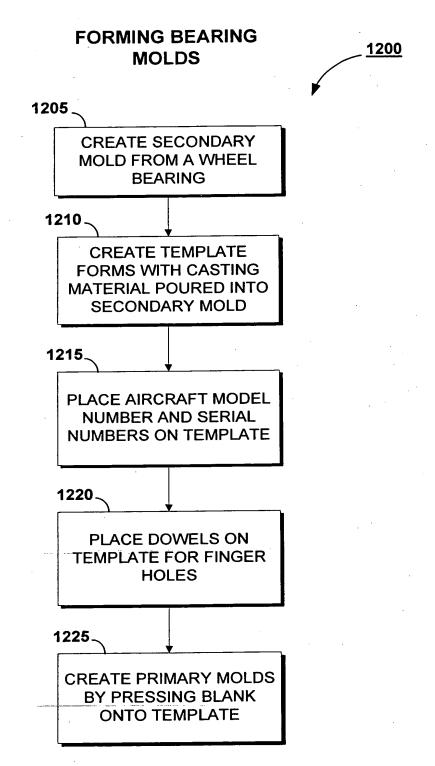


FIG 12